

Work Order ID 60169-1

June 28, 2010 12:02:47 PM



Page 1

Item ID: D4134-042

Accept

Revision ID:

Item Name: Wearplate, RH Aft

Start Date: 6/28/10 Start Qty: 2.00

Required Date: 7/15/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

QC:

Date: 10/6/29 Tooling:

Date: SPC (Y/N):

Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4134

A

100



Waterjet

FLOW CNC Waterjet

304 050

FLOW WATERJET

Memo

1-Cut D4134-1F as per Dwg D4134

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

0.00

0.00

B.O.C. 29

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10/6/29

120



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

8/10/06/30

(+3)

(3)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60169

June 28, 2010 12:02:48 PM



Page 2

Item ID: D4134-042

Accept

Revision ID:

Item Name: Wearplate, R11 Aft

Start Date: 6/28/10 Start Qty: 2.00

Required Date: 7/15/10 Req'd Qty: 2.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130

Form as per dwg

0.00



Brake NC

Memo

B079

0.00

Brake NC

I- Form using DT Die as per Dwg D4134

DT 9641

83 10/07/13

3
B1007.13 - acc only

DTD

140

QC 5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

P 10.07.14 1

150

Weld per dwg A/R Hardcoat S.S. Batch 1114705

0.00



Large Fab

Memo

0.00

Large Fab

Weld hard surface using DT as per QSI 004 and Dwg D4134

N/A

10.07.13 1

W/O:			WORK ORDER CHANGES					
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Work Order ID 60169

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Item ID: D4134-042

Revision ID:

Item Name: Wearplate, RH Aft

Start Date: 6/28/10 Start Qty: 2.00

Required Date: 7/15/10 Req'd Qty: 2.00

Reference:

Approvals: Process Plan:

Date:

QC:

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC10- Inspect visual per QSI004- ground welds

0.00

QC

Memo

0.00

Quality Control

170

QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

180

Grey Sandtex(Ref:4.3,5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 1:00pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 1:30pm

Pha

Per 6/2/10

①



Accept



Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Sub 1/15

⑩

① 10-07-14 ①

① 10/07/15 1 9

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 60169

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Item ID: D4134-042
Revision ID:
Item Name: Wearplate, R11 Alt
Start Date: 6/28/10 Start Qty: 2.00
Required Date: 7/15/10 Req'd Qty: 2.00
Reference:

Accept

Setup Start
Stop

Cust Item ID:
Customer:

Approvals: Process Plan: Date: Tooling: Date: Run Start
QC: Date: SPC (Y/N): Date: Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp

190
QC
Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

10-07-15 @

200
Small Fab
Small Fab

Memo

0.00

1- Bond D4134-3 gasket to inner surface of wearplate using a thin layer of 3M
1300/1300L scotch grip adhesive
Batch: M113174

10-07-15 @
= 7 m. L

210
QC
Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10-07-15 @

MS

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60169

Friday, July 16, 2010 10:01:30 AM



Page 5

Item ID: D4134-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearplate, RH Air

Start Date: 6/28/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/15/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220



Packaging

Packaging

Identify as per dwg & Stock Location: _____

0.00

Packaging

Memo

0.00

Rec'd 7/14 (1)

230



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10-7-16

ME 10-7-16

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 28, 2010 12:02:46 PM

Page 1

Work Order ID: 60169

Parent Item: D4134-042

Parent Item Name: Wearplate, RH Aft



Start Date: 6/28/10

Required Date: 7/15/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.25 new issue DD VER:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4134-3 		Manufactured	No			200	Each	0.0000	1	2			
Gasket M304S18G/A 		Purchased	No			100	sf	132.8779	1.5825	3.331579	4.8		
304/316 .050 Sheet 													

Location

MAT20

Loc Qty

132.8779

Loc Code

111743

8.86

112885

28.0179

113062

96

B10-6-29

(3)

13002

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)					
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X	X	D4134-041	WEARPLATE, LH AFT
		D4134-042	WEARPLATE, RH AFT
1		D4134-1	WEARPLATE
1	1	D4134-2	WEARPLATE
1	1	D4134-3	GASKET
A/R	A/R	1300/1300L	3M SCOTCH-GRIP ADHESIVE

D4134-041 WEARPLATE, LH AFT

D4134-042 WEARPLATE, RH AFT

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QST 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4134-xxx" USING YELLOW PAINT MARKER ON INSIDE SURFACE
- 7) WEIGHT: -041/-042 = 2.2 lbs
- 8) BOND D4134-3 GASKET TO INNER SURFACE OF WEARPLATE USING A THIN LAYER OF 3M 1300/1300L SCOTCH GRIP ADHESIVE

REV.	NEW ISSUE	DESCRIPTION	CP	10/06/15
DESIGN			BY	DATE
DRAWN	99	DART AEROSPACE USA, INC		
CHECKED	99	PORT HADLOCK, WA		
MFG. APPR.		DRAWING NO.	REV. A	
APPROVED		D4134	SHEET 1 OF 8	
DE APPR.		TITLE	SCALE	
DATE	10.06.15	WEARPLATE, AFT	NTS	

RELEASED
2010-06-23

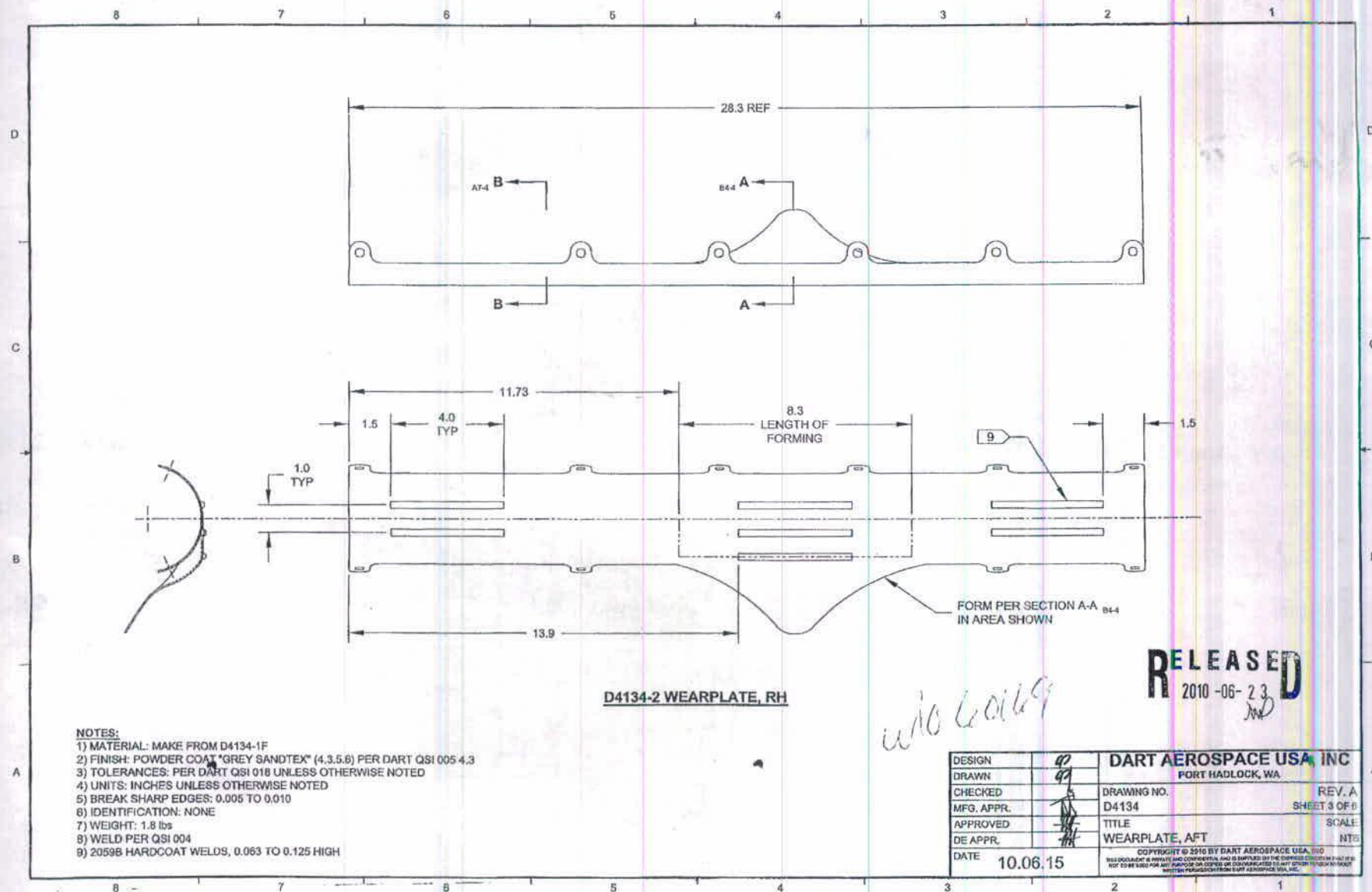
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries



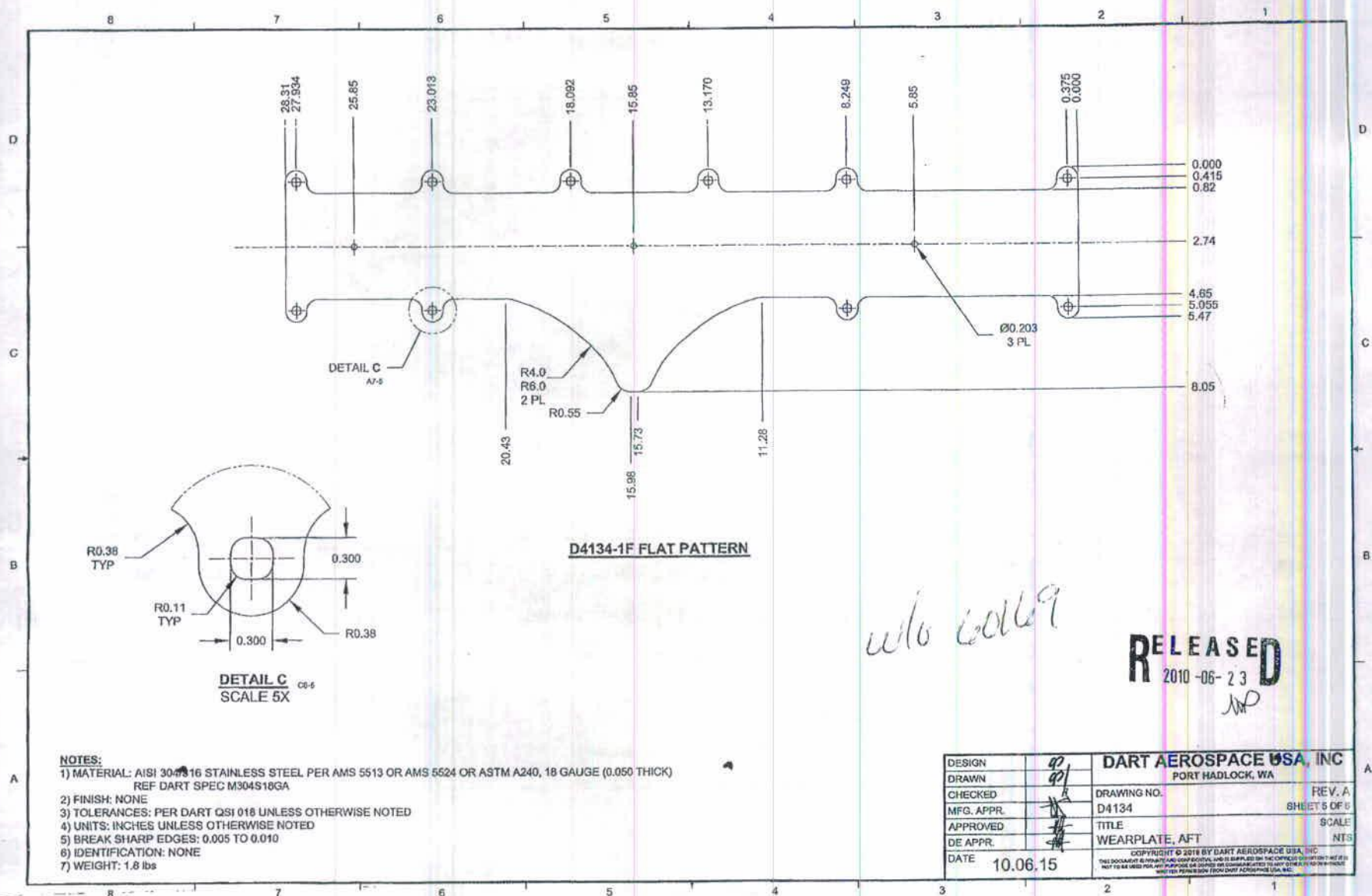
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



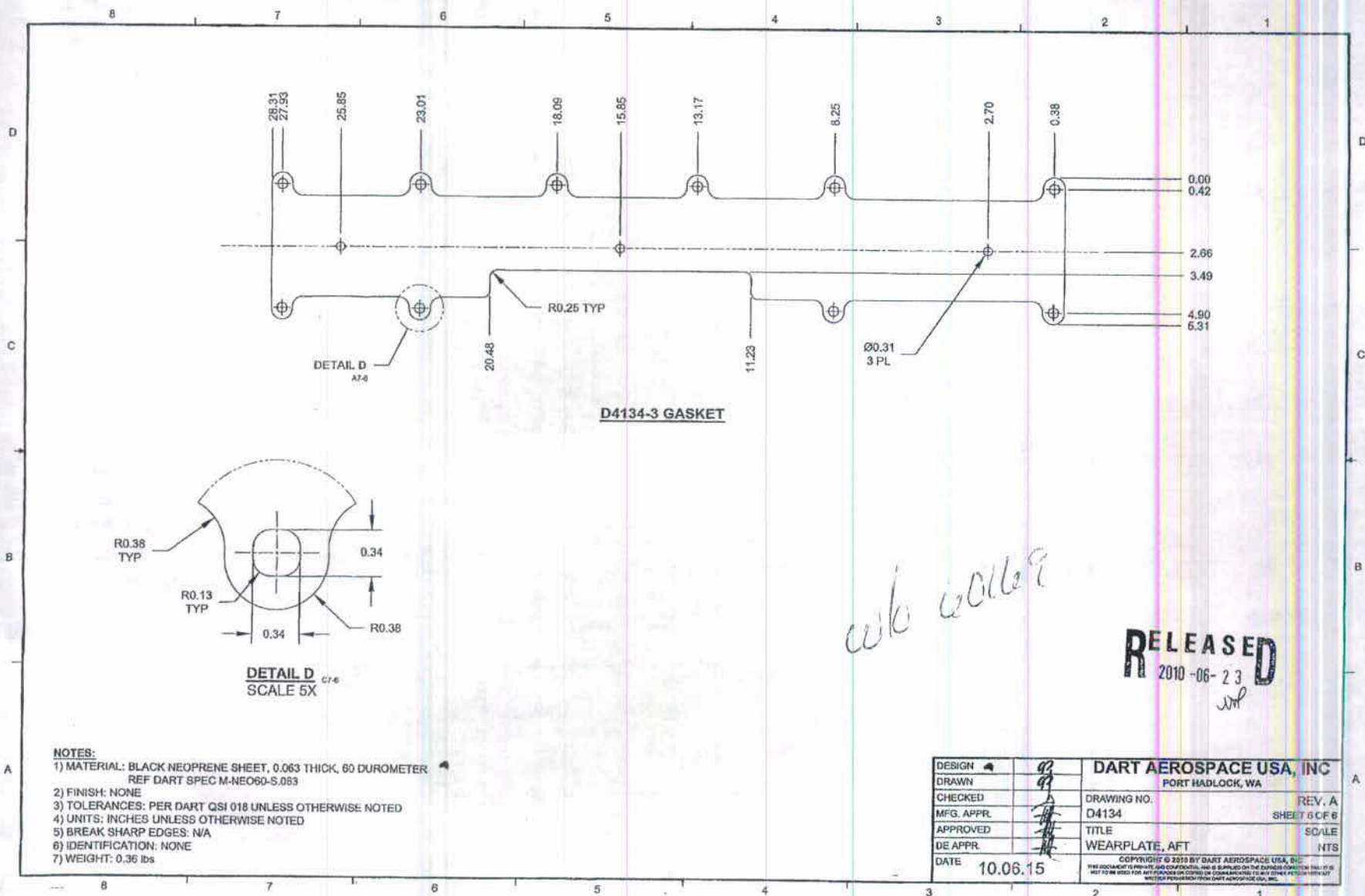
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W/O:			WORK ORDER CHANGES					
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Resolution _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 60169
Description: WEAIRPLATE RH. APT.		Part Number: D4134-042
Inspection Dwg: D4134-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.300	±.002	.303	X			
.300	±.010	.303	2			
.415	±.010	.412	2			
.82	±.030	.816	X			
2.74	±.030	2.775	X			
4.65	±.030	4.640	2			
5.055	±.010	5.053	X			
5.47	±.030	5.468	+			
7.203	±.005 - .001	7.205	X			
.375	±.010	.374	X			
5.85	±.030	5.85	2			
8.249	±.010	8.250	2			
13.170	±.010	13.170	2			
15.85	±.030	15.85	2			
18.092	±.010	18.092	X			
23.003	±.010	23.018	X			
25.85	±.030	25.85	2			
27.934	±.010	27.934	X			
28.31	±.030	28.310	X			
8.05	±.030	8.048	2			
15.73	±.030	15.73	2			
15.98	±.030	15.98	2			
.050	±.010	.050				

Measured by: LS	Audited by: C	Prototype Approval: N/A
Date: 10-6-29	Date: 10/6/30	Date: N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

W/O:			WORK ORDER CHANGES					
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Dart Aerospace Ltd

WORK ORDER CHANGES

W/O:						Approval Chief Eng / Prod Mgr	Approval QC Inspector
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty		
10/07/13	130	Had to open hole at .311 to match the fig	SS	10/07/13	3	10.07.13 B. W.	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:		WORK ORDER NON-CONFORMANCE (NCR)					Verification Section C	Approval Chief Eng	Approval QC Inspector
DATE	STEP	Description of NC Section A	Corrective Action Section B						
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries